

Work Order ID 77529

77529

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December-12-11 3:01:50 PM

Item ID: D3825-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Rib Assembly (Basket End)
Start Date: 12/12/2011 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 16/12/2011 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: M.C.J Date: 11/12/12 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3825	Rev A

100

0.00

100

Large Fab

Large Fab

0.00

Large Fab

Memo

1- cut D3825-1 rib as per dwg D3825

2- drill hole (3/16") in D3825-1 using DT9438 jig and open to finish size as per dwg D3825

3- c'sink hole as per dwg

4- remove identification markings

5- deburr

6- weld D2327-3 spacer bushing and D3759-1 bushing as per dwg D3825

A/R S.S. Rod Batch: M114649

7- grind bushing weld flush where indicated on dwg D3825

8- deburr if necessary

bx

Pl 11.12.19

PC 11.12.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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N900040100

Setup Start *NS1*

Stop *NS2*

6

Cust Item ID:

6

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

0.00

130

QC

Memo

0.00

Quality Control

140

0.00

140

QC

Memo

0.00

Quality Control

150

0.00

150

Packaging

Memo

0.00

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 77529***77529***

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

11/12/20
6

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

December-12-11 3:01:55 PM

Page 1

Work Order ID: 77529

77529

Parent Item: D3825-041

D3825-041

Parent Item Name: Rib Assembly (Basket End)

Start Date: 12/12/2011

Required Date: 16/12/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2327-3

Manufactured

No

100

Each

49.0000

1

6

D2327-3

Spacer Bushing

**

Ac 11.12.14

Location

Loc Qty

Loc Code

WA005

49

74782

19

75564

10

77229

20

(x6)

D3759-1

Manufactured

No

100

Each

297.0000

1

6

D3759-1

Bushing

**

Ac 11.12.14

Location

Loc Qty

Loc Code

WA005

297

66489

2

72316

14

74443

80

74783

201

(x6)

M304TS0.750W.065

Purchased

No

100

f

326.4874

2.125

13.42105

M304TS0 750W 065

304 SQ Tube .75x.75x.065W

**

Ac 11.12.14

Location

Loc Qty

Loc Code

MAT018

304.8232585

117636

67.9987

118773

236.824559

WA007

15.5974906

116267

14.628472

116763

0.9690186

WA035

6.0667

118181

6.0667

(13.4210)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

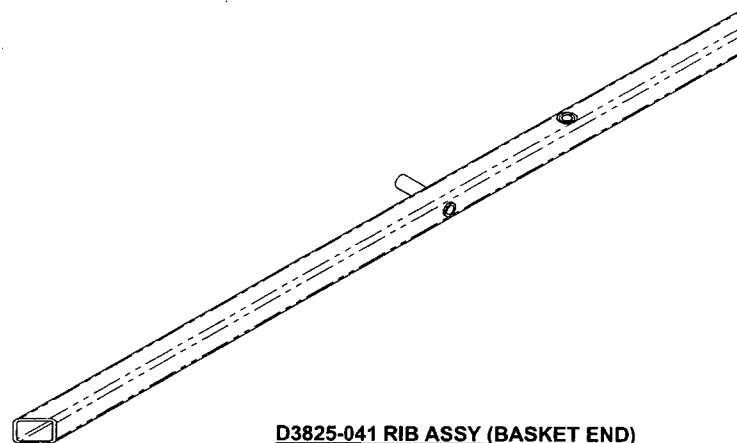
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NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
1	X	D3825-041	RIB ASSEMBLY (BASKET END)
2	1	D2327-3	SPACER BUSHING
3	1	D3759-1	BUSHING
4	1	D3825-1	RIB



D3825-041 RIB ASSY (BASKET END)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 77529 M.L.J
11/12/12

RELEASED
08/11/18

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.22 lbs
 - 8) WELDING: PER DART QSI 004

A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.23		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3825
REV. A
SHEET 1 OF 3
TITLE RIB ASSY (BASKET END)
SCALE NTS

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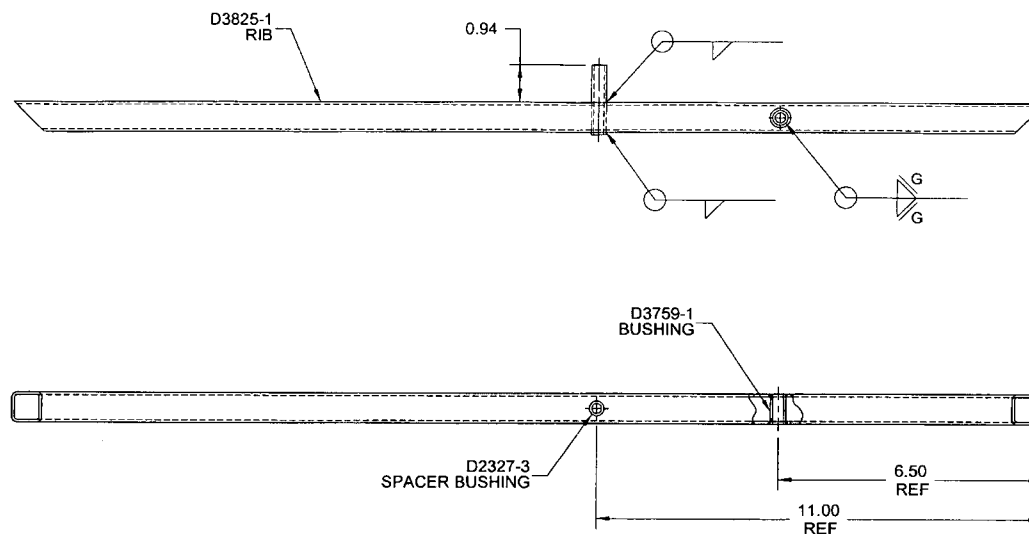
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NOTE: Date & initial all entries

77529



D3825-041 RIB ASSY (BASKET END)

RELEASED
08/11/18 J.W.

DESIGN	16	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. A
MFG. APPR.		D3825	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET END)	NTS
DATE	08.09.23	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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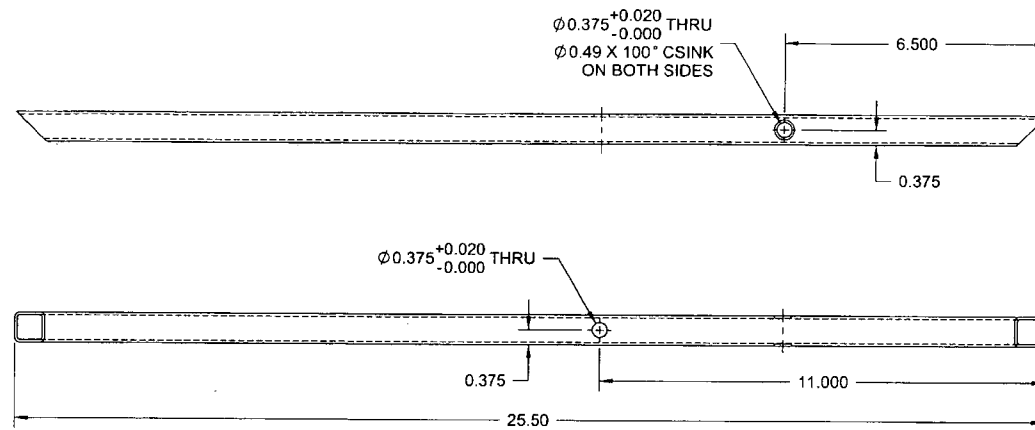
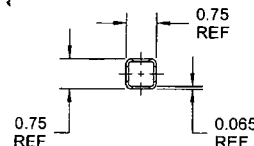
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D3825-1 RIB

RELEASED
08/11/13

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.18 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3825	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET END)	NTS
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